

Date: Tuesday, 4/25/2006 7:36:54 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	ARMOR SHIELD
Job Number	26812	Part Number	D412664203A
Estimate Number	12369	Drawing Number	DSI9326
P.O. Number	N/A	Project Number	N/A
This Issue	4/25/2006	S.O. No.	N/A
Prsht Rev.	NC	Drawing Revision	A
First Issue	N/A	Material	N/A
Previous Run	26729	Due Date	5/5/2006
Written By	SAR/ Comment Below	Qty:	1 Um: Each
Checked & Approved By	06.04.25		
Comment	Est Rev: A New Issue 06-04-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :																
1.0	DC	DOCUMENT CONTROL																
		Comment: Photocopy bluefile & type labels per PPPD412-664-203A CHG001 Add DSI 9326 to existing paper work.																
2.0	D412664203	Crosstube Aft High																
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Fwd Crosstube Batch: B29778																
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1																
		Comment: HAND FINISHING RESOURCE #1 1-Remove tube from packaging																
		2-Apply Armor shield as per DSI 9326 A/R Armor Shield Batch: M18328																
4.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION																
		Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION																
5.0	PACKAGING 1	PACKAGING RESOURCE #1																
		Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-664-203A Location: <u>DRNT</u> PPP Rev: <u>04/04</u>																
		<table border="1"> <tr> <td>PN</td> <td>D412-664-203</td> <td>CHG</td> <td>CHG003</td> </tr> <tr> <td>DESC</td> <td>Crosstube Aft High</td> <td>SIC</td> <td>SH01-9</td> </tr> <tr> <td>LOT</td> <td>B24778</td> <td>SIC</td> <td>SR01298NY</td> </tr> <tr> <td>MODEL</td> <td>Bell 412</td> <td>STC</td> <td></td> </tr> </table>	PN	D412-664-203	CHG	CHG003	DESC	Crosstube Aft High	SIC	SH01-9	LOT	B24778	SIC	SR01298NY	MODEL	Bell 412	STC	
PN	D412-664-203	CHG	CHG003															
DESC	Crosstube Aft High	SIC	SH01-9															
LOT	B24778	SIC	SR01298NY															
MODEL	Bell 412	STC																
		MADE IN CANADA																

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ARMOR SHIELD

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/05/05

7

Job Completion



U 06/05/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>S.J.</i>	APPROVED <i>CH</i>	DRAWING NO. DSI 9326	REV. A SHEET 1 OF 1
DATE 06.02.14	TITLE ARMOR SHIELD		SCALE NTS
A	06.02.14	NEW ISSUE	

DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment.

INSTALLATION	CANADIAN STC	FAA STC
D205-596-101/-103/-105/-107	SH03-6	SR01742NY
D212-664-101/-201	SH01-9	SR01298NY
D412-664-203		
D206-667-101/-103/-201/-203	SH01-5	SR01304NY
D407-667-105/-205		
D058-676-101/-201	N/A	SR01018SE

To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. It is acceptable to apply the Armor Shield in regions shown in Figure 1 only. It is **NOT** acceptable to apply Armor Shield in the cuff and support/clamp regions.

1.0 To apply Armor Shield

- 1) Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 2) Mask areas around supports and cuffs per Figure 1. Abrade paint finish in areas requiring protection using 320 grit sandpaper.
- 3) Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area
- 4) Apply 3 coats of Proform PF 746 or PF 746-1 to surface (apply additional coats when surface is dry, but not fully cured)
- 5) Allow 5 hours for coating to dry.
- 6) Apply 2 coats of Imron 500s Polyurethane Enamel clear + Dupont Imron Polyurethane Enamel Activator 192S (mix 3:1). Mix 15 minutes prior to application and allow 15 minutes before applying additional coats.

2.0 Armor Shield removal/re-application

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 1) Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2) Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 3) Apply Armor Shield in accordance with Section 1.0 of these instructions.

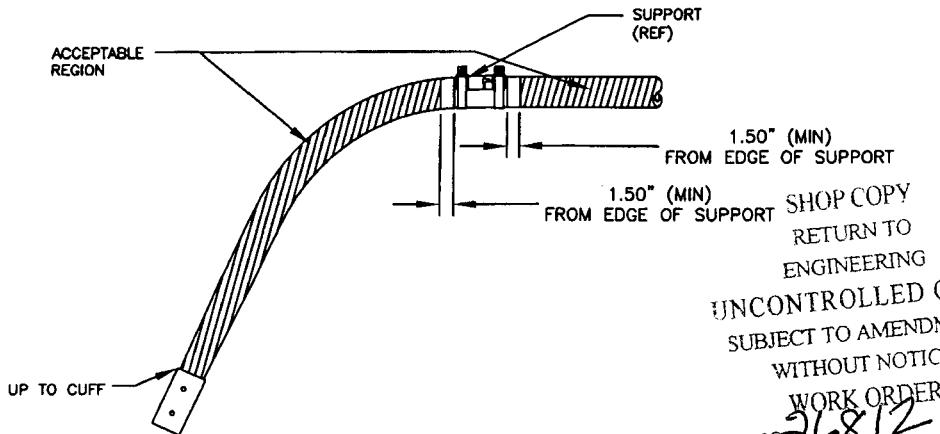


FIGURE 1 – ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>Reyed</i>	
D. SHEPHERD (DE # 02)	
DATE:	06.02.14
CERT. NO.:	SH03-6/SH01-9/SH01-5
ISSUE NO.:	3/3/3

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